

Work Order ID 81124

March-08-12 8:54:39 AM

81124

Page 1

Item ID: D3560-042

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Arm Weldment

Start Date: 08/03/2012 Start Qty: 6.00

Required Date: 22/03/2012 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/09 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3560

Rev D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 16.750" long

B.A 12/04/01

6 0

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA694 Rev: AA & Dwg D3560 Rev: D
 2-C'sink 0.196" hole on manual mill as per dwg D3560
 3-Deburr per dwg D3560

B.A 12/04/08

6 0

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 12-4-10

B.A 12/04/08

6 0

Work Order ID 81124

81124

Page 2

March-08-12 8:54:39 AM

Item ID: D3560-042

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Arm Weldment

Stop ***NS2***

Start Date: 08/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

and 12/04/10

130

QC

Memo

0.00

6

10

Quality Control

140

Large Fab

0.00

140

Large Fab

Memo

0.00

Large Fab

1-Weld assembly as per dwg D3560
STEP:
1- clean material (buff bracket and bottom of arm with blue pad)
2- set up bracket and arm on jig
3- preheat bracket and arm with torch
4- clean before welding with brush
5- set up machine to 135 amps
6- weld across bottom and top ends
7- reheat with torch (65 deg C)
8- on one side weld from bottom to top half way
9- same for other side (half way)
10- from half way point weld the rest of the first side (ease off pedal near end)
11- same for remaining side (ease off pedal near end)

*Alumix. Kod # H9785
120169*

*ll
12-04-12*

Work Order ID 81124***81124***

Page 3

March-08-12 8:54:39 AM

Item ID: D3560-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm Weldment

Start Date: 08/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00

150

8/26/13

QC

Memo

0.00

Quality Control

(40)
-012

/

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

4

0

8/12/04/13

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

7/6-12-4-16

Work Order ID 81124

March-08-12 8:54:39 AM

81124

Page 4

Item ID: D3560-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Arm Weldment

Start Date: 08/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

4

0

hl
12.04.16

190

Small Fab

0.00

190

Small Fab

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

4

0

EP 12/04/16

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

Srdkuli6

20

0.02

210

I identify as per diag & Stock

WA

4

0

hl
12.04.16

Work Order ID 81124

March-08-12 8:54:39 AM

81124

Page 5

Item ID: D3560-042

Revision ID:

Item Name: Arm Weldment

Start Date: 08/03/2012 Start Qty: 6.00

Required Date: 22/03/2012 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Identify as per dwg & Stock Location: UWA

0.00

210

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL ***

4 0 16.04.17

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/4/18 MF
12-04-17

Picklist Print

Page 1

March-08-12 8:54:43 AM

Work Order ID: 81124

81124

Parent Item: D3560-042

D3560-042

Parent Item Name: Arm Weldment

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808

Manufactured

No

100

Each

35.0000

1

6

D2808

Bushing

**

GP 12/04/16

Location

Loc Qty

Loc Code

GA

35

32896

2

79688

33

M6061T6B0.500X05.00
0

Purchased

No

140

f

75.2274

1.395

8.810526

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

**

Location

Loc Qty

Loc Code

MAT001

21.834

112154

6.935

117933

2.123

119346

12.776

MAT004

53.3934

120243

24

120421

5.3934

120866

24

M121040 x 8.82

smk 12/04/16

Picklist Print

Page 2

March-08-12 8:54:43 AM

Work Order ID: 81124

81124

Parent Item: D3560-042

D3560-042

Parent Item Name: Arm Weldment

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

D3592-1

Manufactured No

190

Each

17.0000

1

6

D3592-1

12.02.12

Plate

Location

Loc Qty

Loc Code

WA

15

79715

15

WA002

2

47015

2

4

DART AEROSPACE LTD		Work Order:	81124
Description: Arm		Part Number:	D3560-2
Inspection Dwg: D3560	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	Ø0.5065	✓		Mic	GA-03
Ø0.196	+0.005/-0.001	Ø0.198	✓		Vern	GA-01
Ø1.000	+0.010/-0.001	Ø1.004	✓		"	"
0.500	+/-0.010	0.495	✓		"	"
0.250	+/-0.010	0.252	✓		"	"
0.275	+/-0.010	0.277	✓		"	"
0.188	+/-0.010	0.178	✓		Mic	GA-03
2.000	+/-0.010	2.001	✓		Vern	GA-01
1.700	+/-0.010	1.701	✓		"	"
Ø0.385 x 100°	+/-0.010 x 0.5°	Ø0.385x100	✓		"	"
0.250 Deep	+/-0.010	0.254	✓		"	"

Measured by: G.A. *[Signature]*
Date: 12/04/10

Audited by: *[Signature]*
Date: 12/04/10

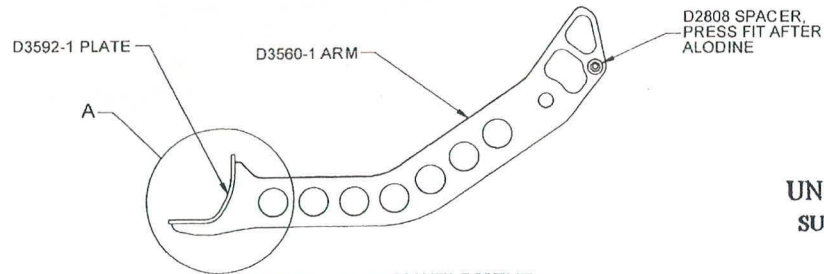
Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-042	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	09.06.11	Dwg Rev updated	KJ <i>[Signature]</i>	<i>[Signature]</i>

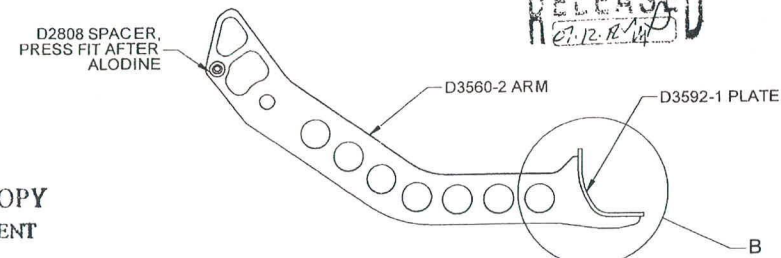
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07.12.16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

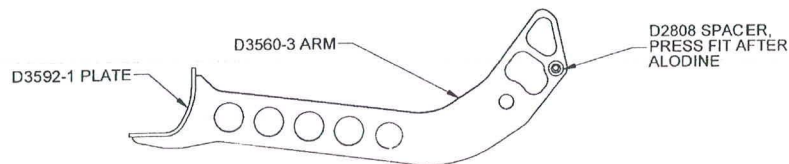
NO. 81124 MLJ
12/03/09



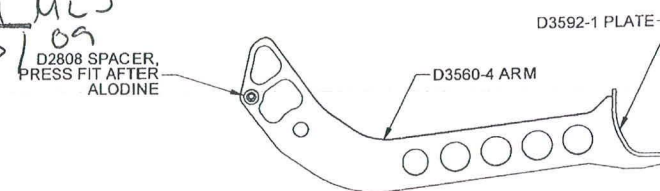
D3560-041 ARM WELDMENT



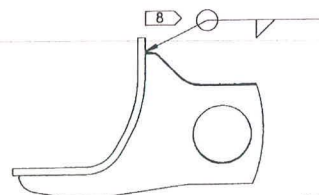
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



DETAIL A
SCALE 1 : 2

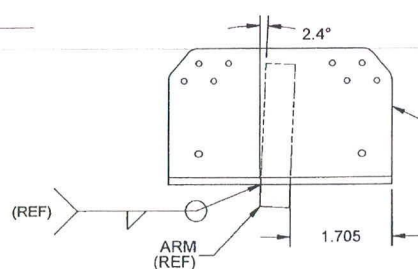
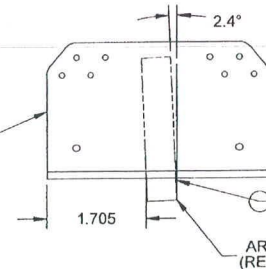
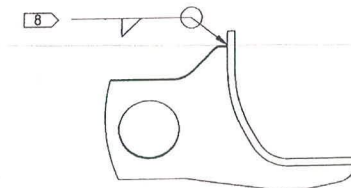


PLATE
(REF)



ARM
(REF)



DETAIL B
SCALE 1 : 2

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

NOTES:

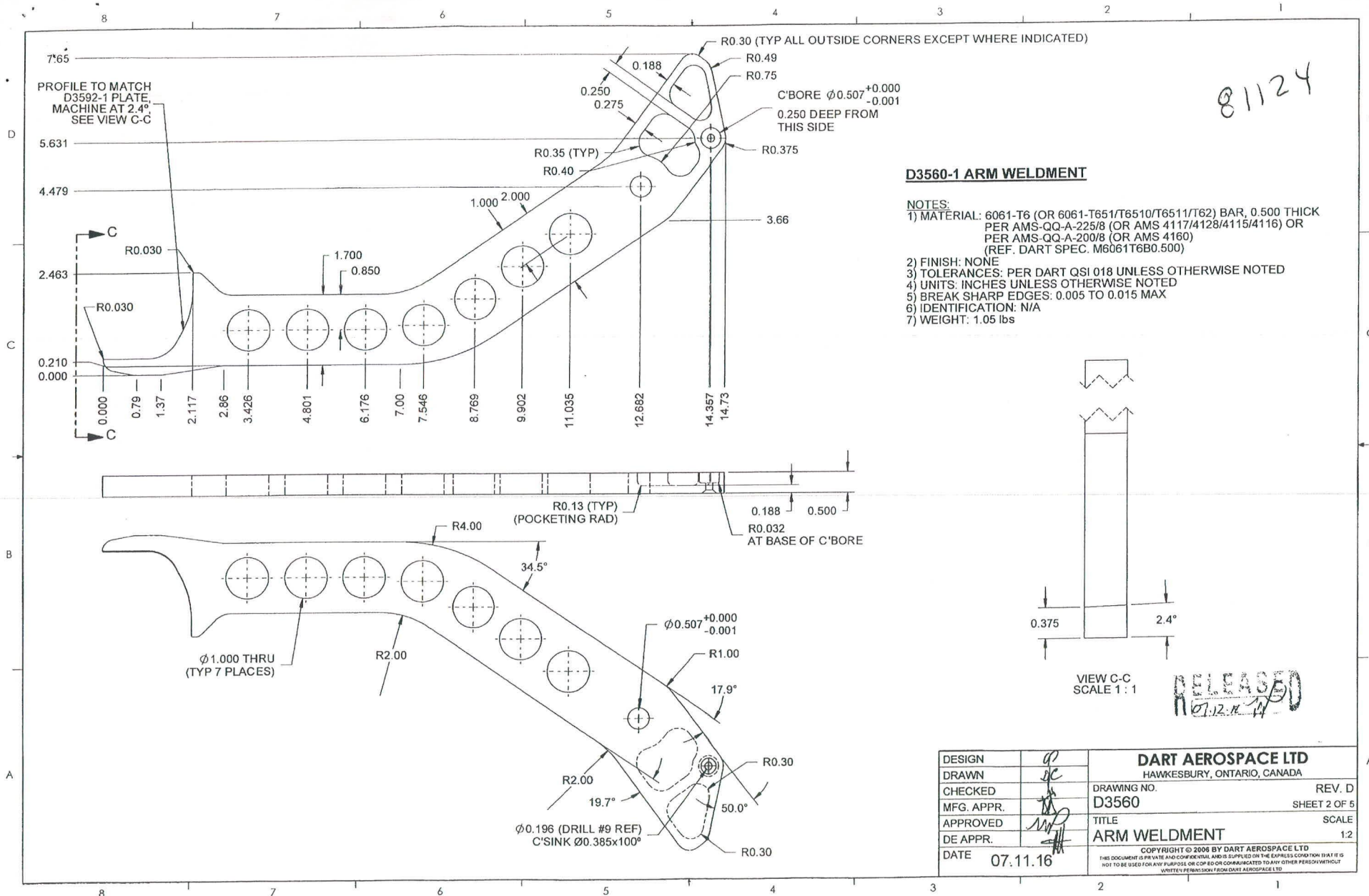
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

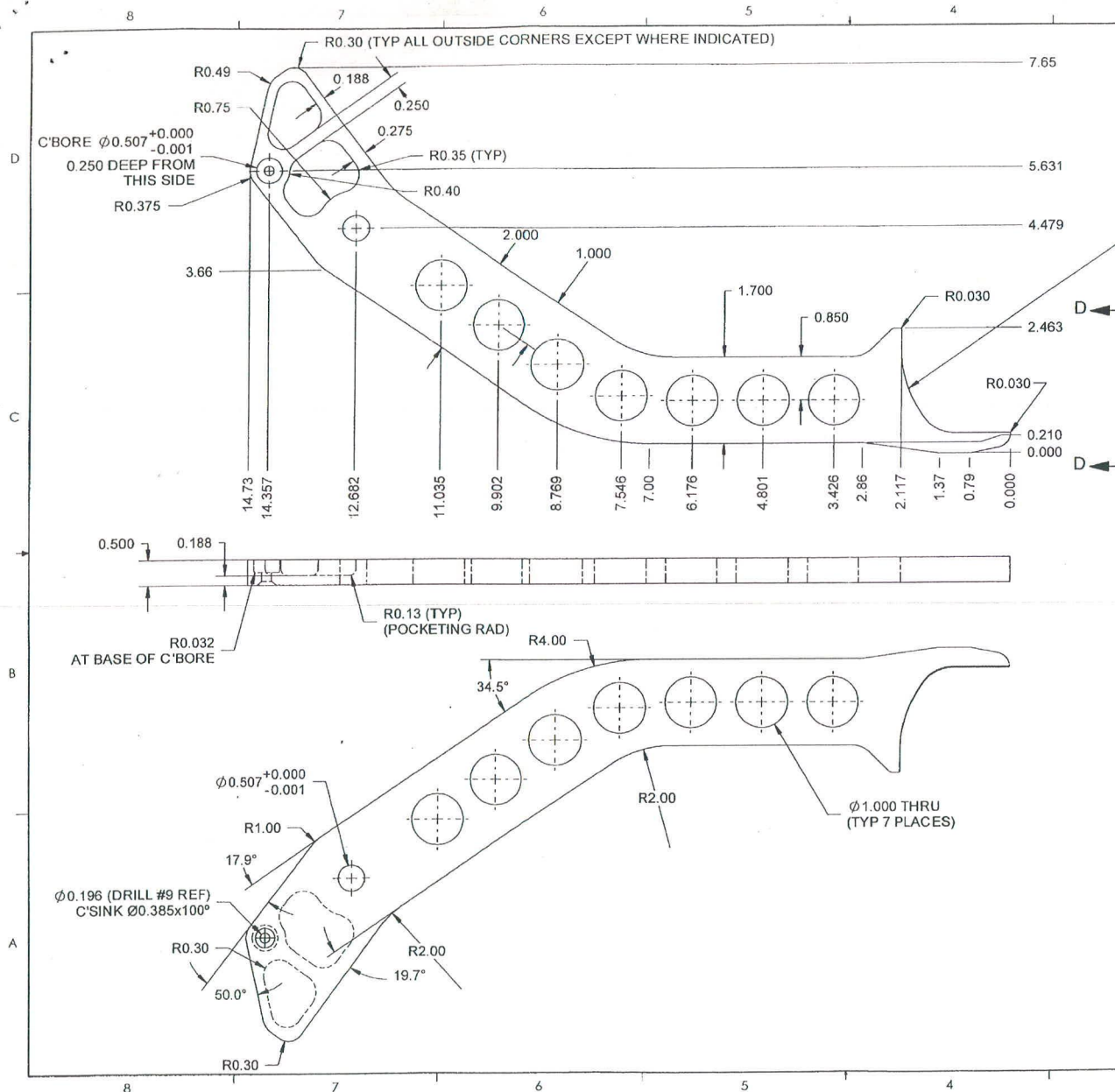
D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3560
TITLE ARM WELDMENT
REV. D
SHEET 1 OF 5
SCALE 1:4

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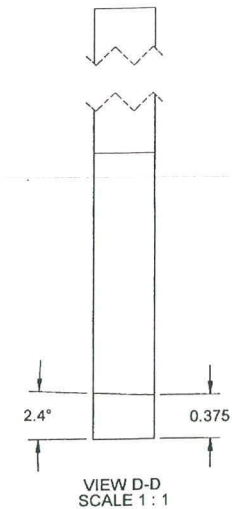




PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4°,
SEE VIEW D-D

D3560-2 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs

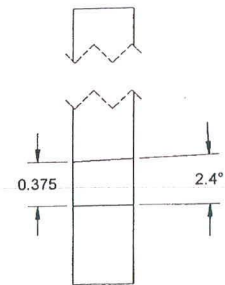


DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
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01124

D3560-3 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs

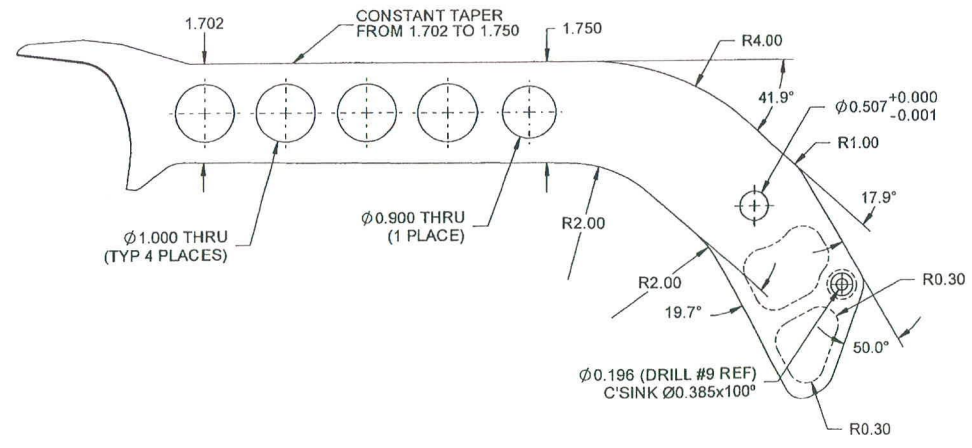
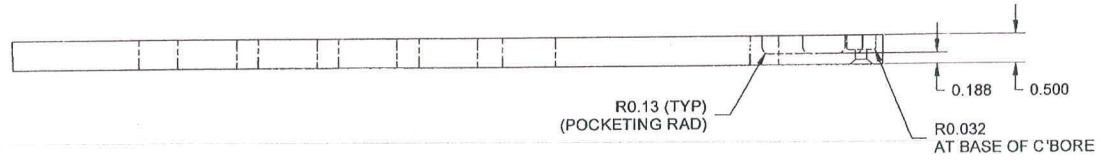
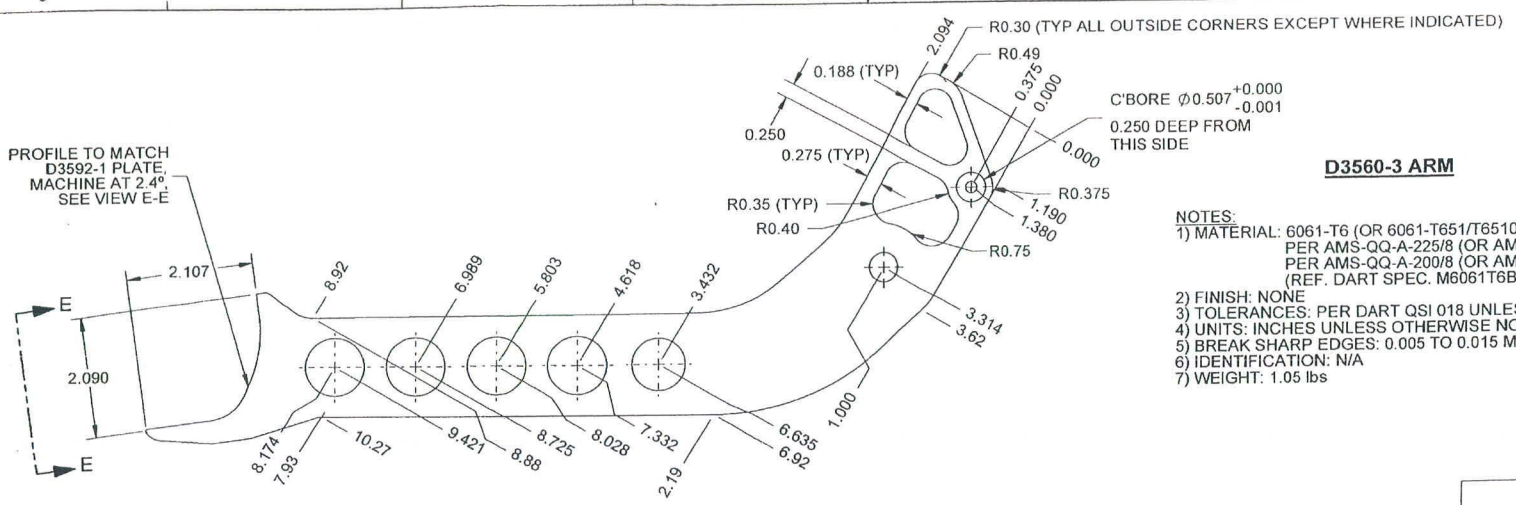


VIEW E-E
SCALE 1:1

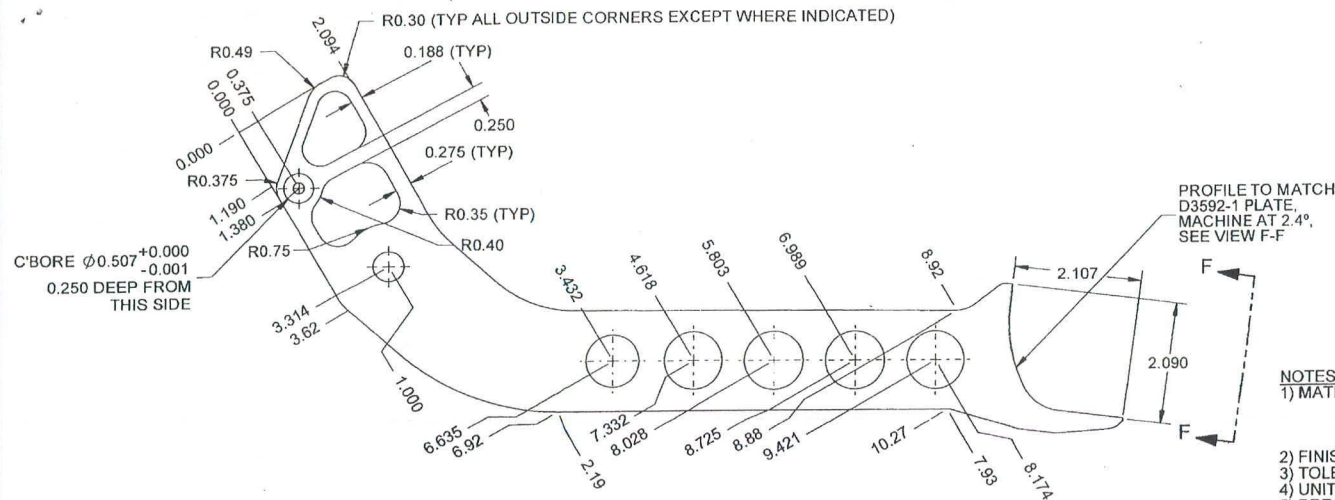
RELEASED
07.12.16

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DRAWN	AC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	g	DRAWING NO.	REV. D
MFG. APPR.	g	D3560	SHEET 4 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	*	ARM WELDMENT	1:2
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PROFILE TO MATCH
D3592-1 PLATE
MACHINE AT 2.4°
SEE VIEW E-E

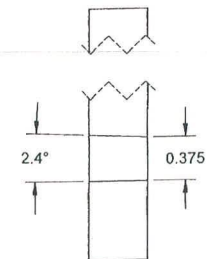
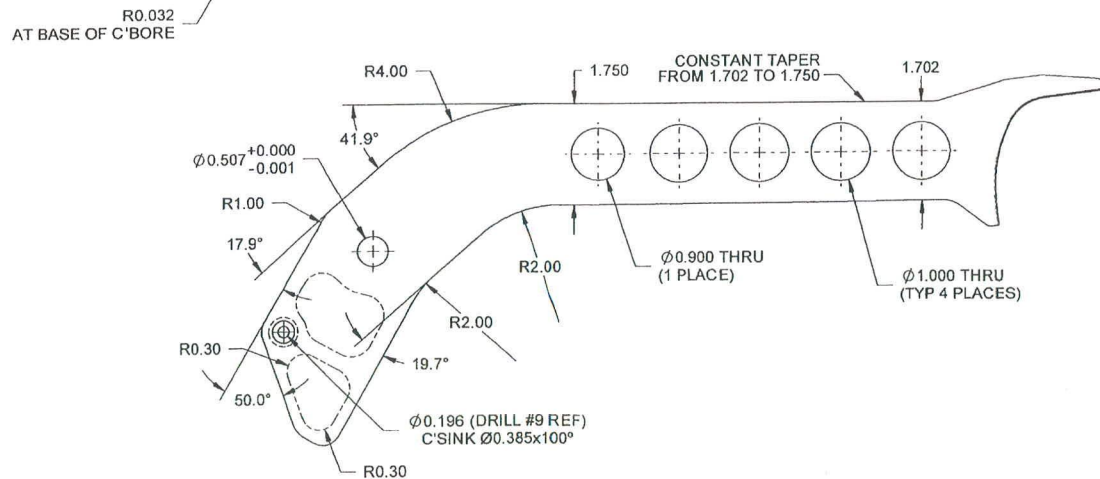
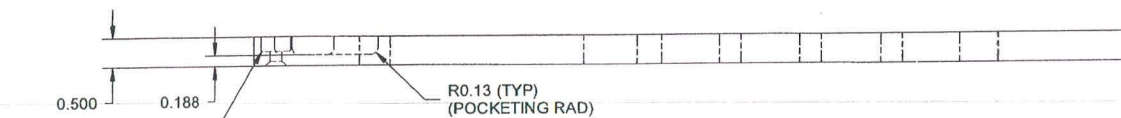


81124



D3560-4 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. D
MFG. APPR.	BC	D3560	SHEET 5 OF 5
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	ARM WELDMENT	1:2
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